

Date: Tuesday, 08/04/2008 4:59:38 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/355 AS X-TUBE AFT UNDER REVIEW
 Job Number : 38495
 Estimate Number : 12486
 P.O. Number :
 This Issue : 08/04/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350748201
 First Issue : / / Type : LANDING GEAR Drawing Number : N/A
 Previous Run : 38494 Drawing Revision : N/A
 Material :
 Due Date : 30/06/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JD 08.4.09
 Comment : Est Rev: A New Issue 06-07-05 JLM
 Est Rev: B Update qty of MS21042L5 06-09-12 KJ
 Est Rev C Combined manufacturing 08.04.02 EC verified by:
 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08-4.23



Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001

2.0 D350748241TRN CROSTUBE TURNING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 CROSTUBE TURNING DETAIL
 batch 638002

FL 8-6-23

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE
 Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

DP 8-6-24

4.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

08-06-24 (1)

5.0 CROSTUBES CROSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
 1-Remove all marks from tube within limits of D350-748-241

SL 8-6-25

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
 Set-up drill table as per QSI 010

08-06-24

PTO


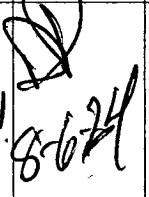

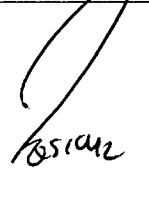
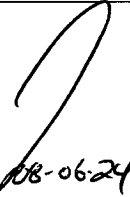
3-Deburr

SL 8-6-25

38 8-6-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: N/A Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 08/08/06
 QA: N/C Closed: _____ Date: _____

NCR: 38495		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-06-24	5.0	- Tube is slightly uneven on the height. - still developing the program and tangent line positioning New program		Trim off 0.1875 from cuff 'A' - 0.23 from cuff 'B' to even the height.	 08/06/06	 08/06/06	 08/06/06	 08-06-24

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:59:38 PM
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Drawing Name: 350/355 AS X-TUBE AFT UNDER REVIEW

Job Number: 38495

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Engrave Part # and Batch # as per Dwg D350-748-241

RT 08-06-24

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/02/15

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 6784

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

C 208107116 ①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

JS 08/08/11 (x4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 8/8/11

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

> ml 08 08 20

①

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

IT 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT UNDER REVIEW

Job Number: 38495

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SUPPORT

Batch: 35783

ml 08 08 21

13.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

ml 08 08 21

14.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch: 100489

ml 08 08 21

15.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch: 108558

ml 08 08 21

16.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 106484

ml 08 08 21

17.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

Batch: 108986

ml 08 08 21

18.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

ml 08 08 21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38495

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

ml 08 08 21 (1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D35001

350 SADDLE



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

350 SADDLE

Batch: B35315

scf

22.0

D35011

BUSHING



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

BUSHING

Batch: B32209

scf

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M107334

scf

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M105940

scf

25.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 107013

8/8/22

(1x)

scf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 08/04/2008 4:59:38 PM
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Drawing Name: 350/355 AS X-TUBE AFT UNDER REVIEW

Job Number: 38495

Part Number: D350748201

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	AN960JD416	Washer
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M108161

SC

27.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M108246

SC

28.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M107499

SC

29.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M108471

SC

30.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

31.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location:

PPP Rev: A

(IX)

SC

32.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion



MF 08.08.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

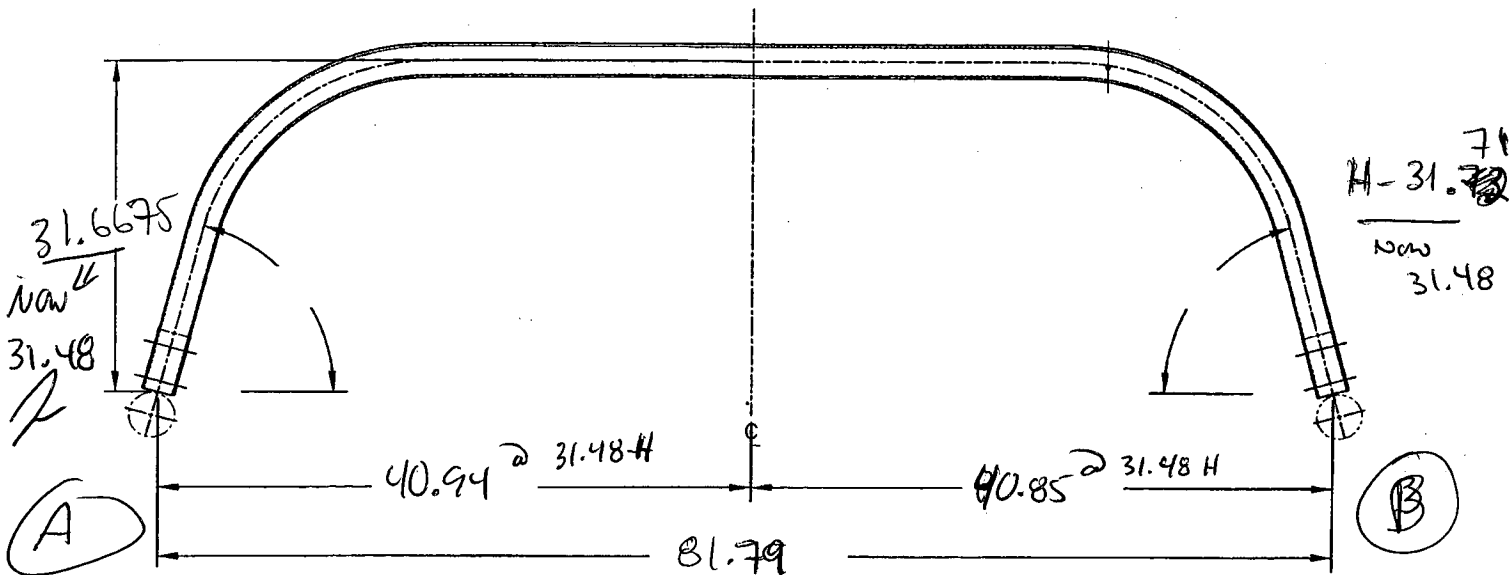
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38495
Description: Crosstube High Aft (AS350/355)		Part Number: D350-748-201
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
Trim cuffs at A 0.1875" B 0.23"

QC15 Inspection	
Date	08.02.24

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

DART**RELEASED**

06.10.31

DESIGN 92	DRAWN BY 92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE NTS	
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 38495

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

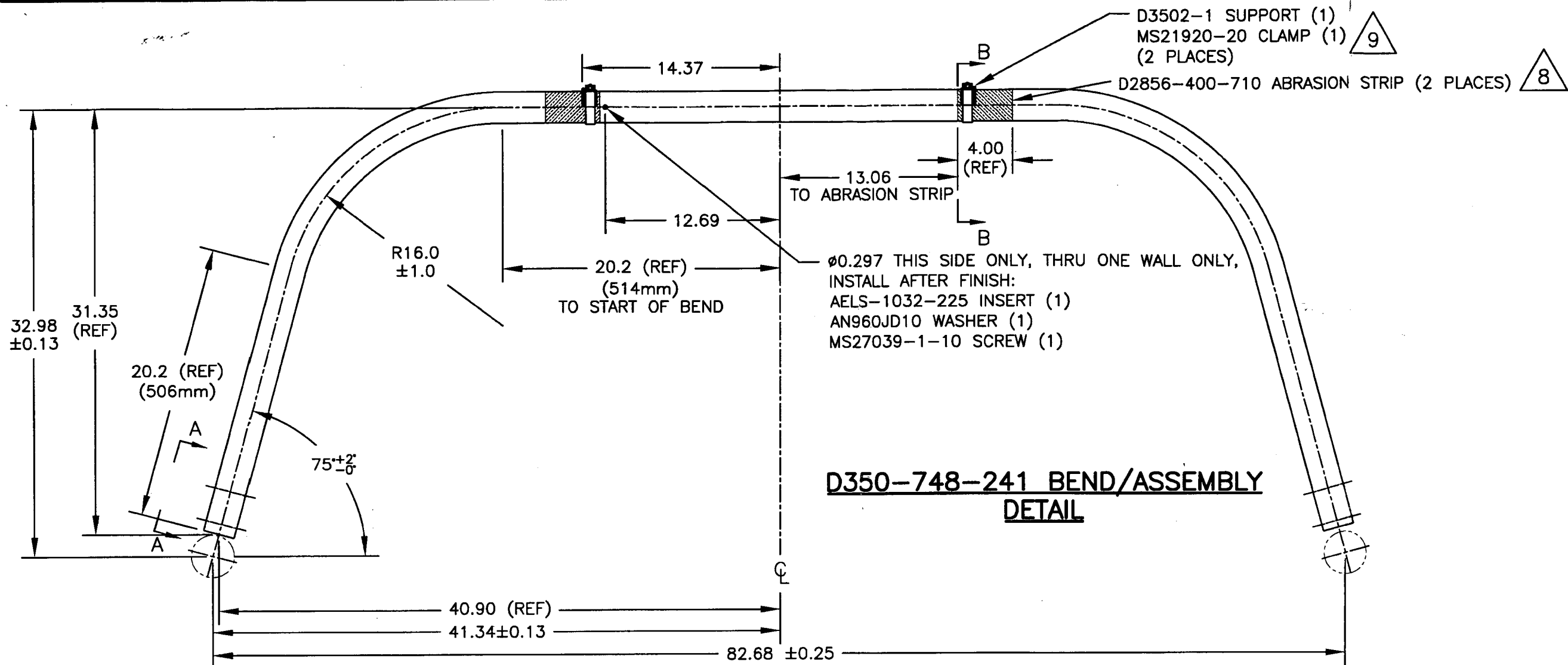
07.02/16

CUT FOR REVIEW

OK 07.11.22

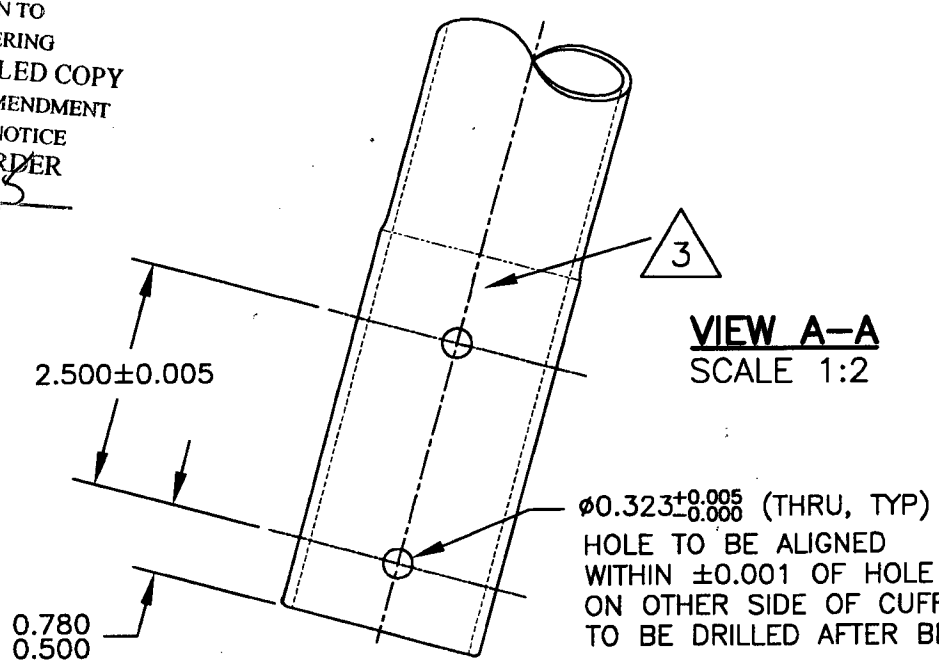
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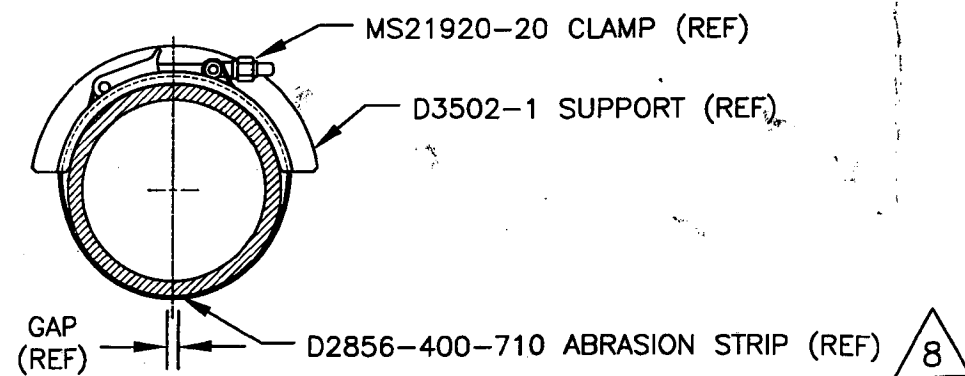
**D350-748-241 BEND/ASSEMBLY
DETAIL**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34495



**VIEW A-A
SCALE 1:2**

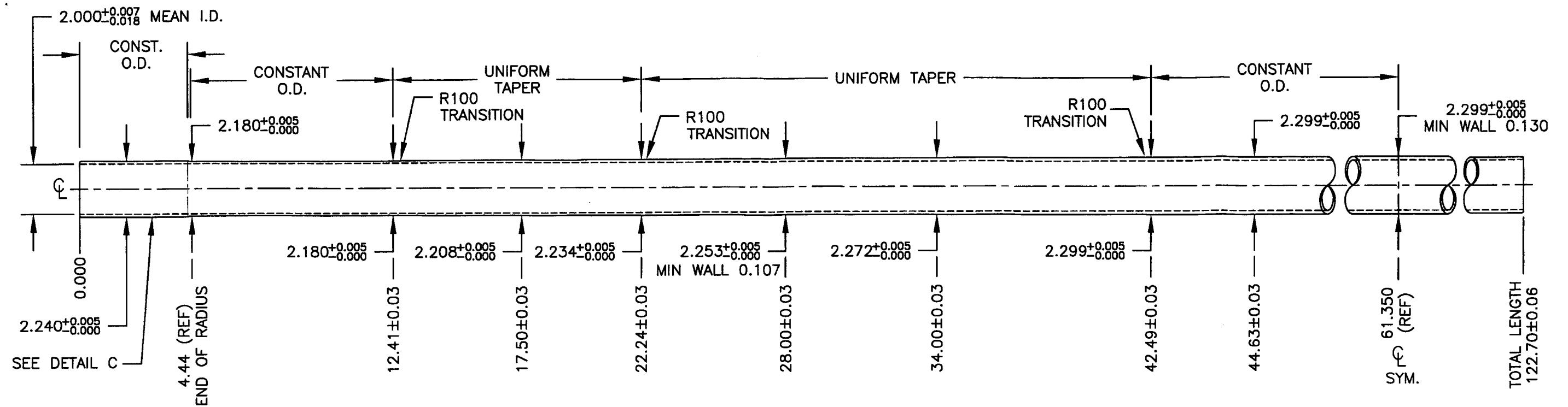
**SECTION B-B
SCALE 1:2**



UNDER REVIEW
07.02/16
CUFF (REF) (REDUCED)
OK CP.07.N.22

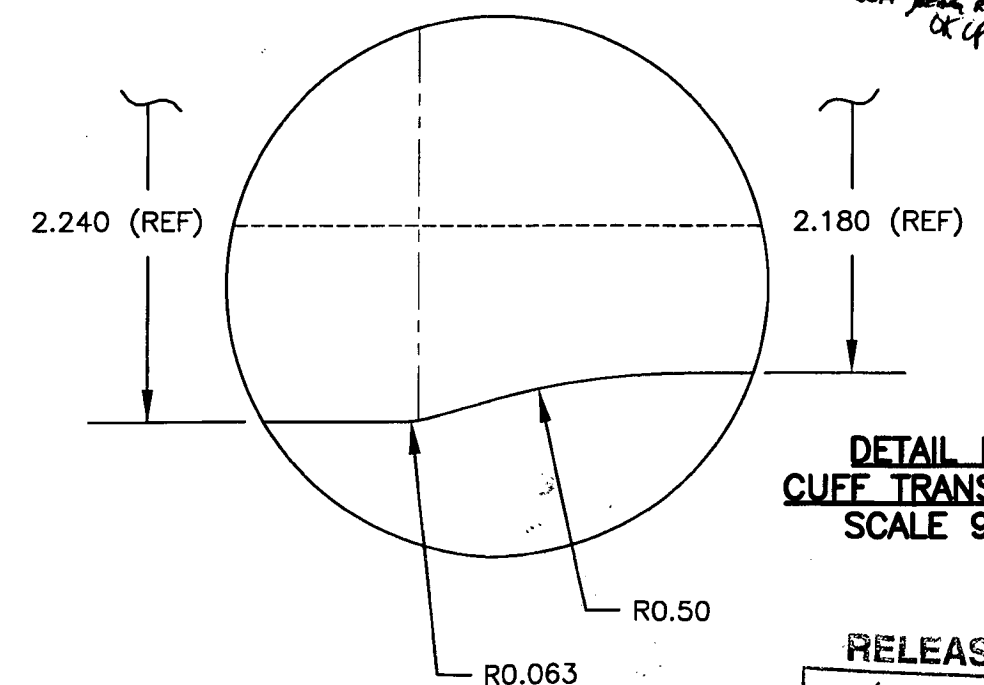
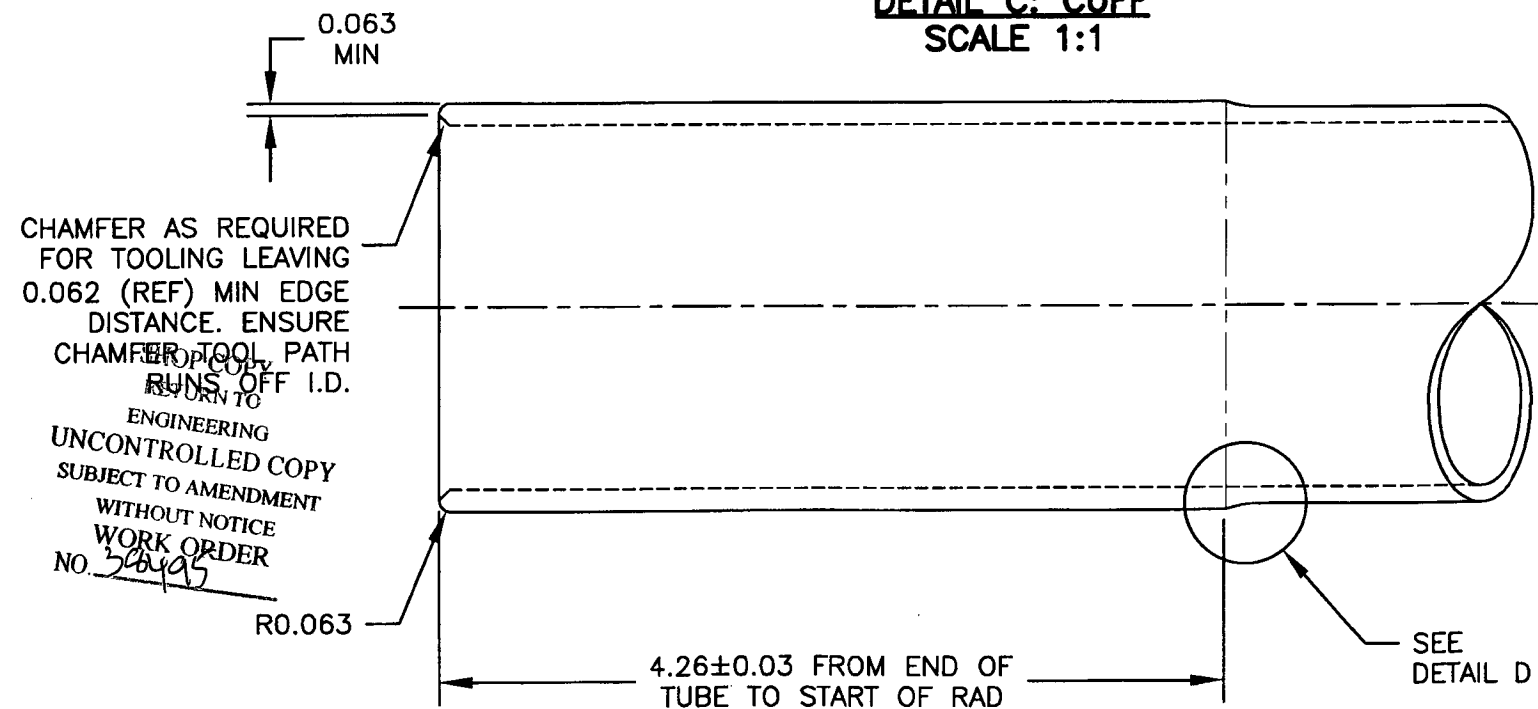
RELEASED
06.10.31

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		DATE	06.10.31			D350-748-241	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE (AS 350/355 HI AFT)	1:8



D350-748-241 MACHINING DETAIL

DETAIL C: CUFF
SCALE 1:1



**DETAIL D:
CUFF TRANSITION**
SCALE 9:1

UNDER REVIEW
07.07/16
CUFF ~~REDESIGNED~~
OK 07.11.22

RELEASED
06.10.31

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DESIGN 07	DRAWN BY 07	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED 11	APPROVED 11	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:4	

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jul-31-2008

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St
Hawksbury, ON K6A 1K7

W/O #: 78312

INVOICE #: 40443

**CONTRACT OR
PURCHASE ORDER #** P00006784

8/2/11

DESCRIPTION: SKID

QTY 1

P/N # D350-748-201

S/N # B38495

**CADMIUM PLATE IAW AMS-QQ-P-416B TYPE 2 CLASS 1. HEAT
CHART #9418 & #9461.**

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:

William Marzetti

